

# Work Order ID 53062

October 22, 2009 1:59:55 PM



Page 1

Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Customer:

Required Date: 04/11/2009 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *PL*

Date: *09-10-22*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D130-780

B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D130-780-042 CHG 003

*Diolarlio*

*HJG MF 10-8-17*

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*10/8/17 SP*

120

0.00



Small Fab

Memo

0.00

Small Fab

-Assemble as per dwg D3188,  
-use door to transfer drill hole location.  
-Install inserts

*ET 10-08-16*

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Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	S 10/08/16						
140  HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 115028  Memo TOP SURFACE OF POD	0.00  0.00							10-08-16
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							10 08 16 1

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Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/18/178

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

510109110

10

Ph →

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-780-042

Location: 115

PPP Rev: C

10/18/178 10/19/10

W/O: 53062

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/8/17	#100	Perm. change Part missing on <sup>W/O</sup> Part List ADD to kit - D3815-5 B# 61318 x3 per kit - S ✓ - MS24694554 B# 115371 x6 per kit - S ✓ - 173235-020-935 B# 106150 x8 per kit - S ✓ - MS2105943 B# 114718 x10 per kit - S ✓	SL SW	10/8/17 10/8/22			S 10/08/17
10/8/17	#100	update W/O + Bom. ADD copy of new Bom for Ref.	NA	10.09.14			S 10/08/17

Part No: D130-780-042 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

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Item ID: D130-780-042

Accept



Setup Start



Revision ID: B

Stop



Item Name: SPACEPOD RH

Start Date: 21/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

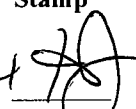


QC

Memo

0.00

Quality Control

10/09/14   
CY 10/9/13

# Picklist Print

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Page 1

Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D130-780-044RevA		Manufactured	No			110	Each	0.0000	1.0000			
Spacepod Door Assembly, RH						353 073					RT 10-08-10	
D3188-2MRevE		Manufactured	No			110	Each	1.0000	1.0000			
SPACEPOD BODY RH						358925					RT 10-08-10	

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

CA

1

46180A

1

AKS4-1032-130

Purchased

No

110

Each

1.0000

28.0000

Inserts

114 723

RT 10-08-11

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1

6087

1

D3837-4RevB

Manufactured

No

110

Each

5.0000

1.0000

Decal

1603

10/8/17 SP

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

5

46233

5

W/O: 53062

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-08-11	110	add to list <u>NAS 15543 x2 B 11126</u> <u>MS 27039-08-11 x2 B 115749</u> <u>D2179 x2 B 35432</u>	ET	10-08-11			8 10/08/11
				10-09-14			

Part No: D130-780-042 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Picklist Print.

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Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2237RevD1		Manufactured	No			110	Each	81.0000	2.0000			
						58181					BY 10-08-11	
Striker Plate												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5	
46162	5	
Main Warehouse		
ST022	76	
50348	21	
52327	55	

MS20426AD4-5

Purchased

No

110

Each

7,910.000 4.0000



Rivet



BY 10-08-11

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7910	
4067	1097	
6733	1831	
6874	4982	

x4



# Picklist Print.

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Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3538-1RevA		Manufactured	No			110	Each	24.0000	2.0000			
						55012					RT 10-08-11	
Hinge Bracket												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

14

48197

14

Main Warehouse

ST111

10

50336

10

AN526-832R24

Purchased

No

110

Each

201.0000

4.0000



Screw

110179



RT 10-08-11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

201

16895

201

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Shop Packet Print

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# Picklist Print.

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Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH



Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1149DN832J  WASHER		Purchased	No			110	Each	375.0000	2.0000			
<div> <div>115300 x8</div> <div>  </div> <div>ST 10-08-11</div> </div>												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	375	
111193	3	
111359	72	
112385	300	

MS21042L08

Purchased

No

110

Each

407.0000

6.0000



Nut

119016 x6



ST 10-08-11

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	407	
110002	24	
111889	51	
112243	47	
112492	85	
112612	100	
112794	100	

# Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3815-041RevA		Manufactured	No			160	Each	7.0000	2.0000			
Web Assembly												

B53469 10/8/09 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
45729	1	
46356	6	

D3837-1RevB

Manufactured No

160

Each

7.0000

1.0000

Decal

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	7	
46231	7	

10/8/09 SP

D3798-042RevA

Manufactured No

160

Each

2.0000

1.0000

Spacepod Floor

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
50351	2	

B53507 10/8/09 SP

# Picklist Print

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Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3547-1RevA

Manufactured

No

160

Each

22.0000

1.0000

10/8/17 SP

Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

35455

8

50260

14

D3550-1RevB

Manufactured

No

160

Each

17.0000

1.0000

10/8/17 SP

Strut

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

48367

17

D3554-7RevA

Manufactured

No

160

Each

60.0000

1.0000

10/8/17 SP

Ball Stud

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

37674

60

# Picklist Print.

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3015-3RevB

Manufactured

No

160

Each

328.0000

1.0000



Locknut



B58502 10/16/09

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

128

43758

26

44446

49

48238

53

Main Warehouse

ST59

200

51711

200

AN3-3A

Purchased

No

160

Each

161.0000

4.0000



Bolt



M113359 10/16/09

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

161

111925

11

112314

50

112720

100

# Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3-6A		Purchased	No			160	Each	135.0000	4.0000			
Bolt												

M113359 10/18/17 SL

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	135	
112082	7	
112513	28	
112720	100	

AN3-10A		Purchased	No			160	Each	73.0000	2.0000			
Bolt												

M15016 10/18/17 SL

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	73	
111119	73	

AN5-5A		Purchased	No			160	Each	107.0000	1.0000			
Bolt												

10/18/17 SL

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	107	
103585	3	
110363	4	
110865	100	

# Picklist Print

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Work Order ID: 53062



Parent Item: D130-780-042RevA



Parent Item Name: SPACEPOD RH

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN525-10R7

Purchased

No

160

Each

131.0000

38.0000



Screw

*M113359 10/8/17 SP*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

131

106166

30

110844

15

112314

10

112411

76

MS24694-S67

Purchased

No

160

Each

103.0000

7.0000



Screw

*M114341 10/8/17 SP*

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

103

101662

13

106166

1

111965

89

# Picklist Print

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Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R14  Screw		Purchased	No			160	Each	937.0000	8.0000		10/8/09	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

937

104916

937

MS24694-S69

Purchased

No

160

Each

118.0000

1.0000

Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

118

103574

5

110153

13

112492

100

A3235-020-935

Purchased

No

160

Each

694.0000

8.0000

Washer - Countersunk

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

694

104156

3

106150

691



# Picklist Print

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Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

NAS1149D0363J Purchased

No

160

Each

2.0000

2.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2

112314

2

NAS1149D0332J

Purchased

No

160

Each

342.0000

16.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

342

110625

16

110844

126

112794

200

NAS1149D0563J

Purchased

No

160

Each

100.0000

3.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

100

112794

100

# Picklist Print

October 22, 2009 1:59:59 PM

Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH

Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
--------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS21042L3

Purchased

No

160

Each

3,430.000

16.0000

Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

3430

110844

32

111274

35

111668

863

112314

2000

112385

500

MS21042L5

Purchased

No

160

Each

1,077.000

1.0000

Nut

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

1077

110382

10

111127

4

111636

63

112314

1000

# Picklist Print

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Work Order ID: 53062

Parent Item: D130-780-042RevA

Parent Item Name: SPACEPOD RH


Comments:

Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AKS4-1032-130		Purchased	No			160	Each	1.0000	10.0000			
												
Inserts												

M114402 10/18/09

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	1	
6087	1	

D130-780-013RevA  
Switch Relocation

Manufactured

No

160 Each 2.0000 1.0000

CH9001

B53079 10/18/09

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
FG	2	
50272	2	

**GENERAL NOTES:**

1) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")  
18 oz ROVING "E" GLASS (18 oz CLOTH)  
OWENS CORNING MILLED FIBERS, "E" GLASS  
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL  
OR DIVINYCELL  
OR AIREX  
OR KLEGECELL  
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

1. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

2) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S.  
APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: D3188-1 = N/A  
D3188-2 = N/A  
D3188-3 = N/A  
D3188-5 = N/A  
D3188-6 = N/A  
D3188-7 = N/A

8) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

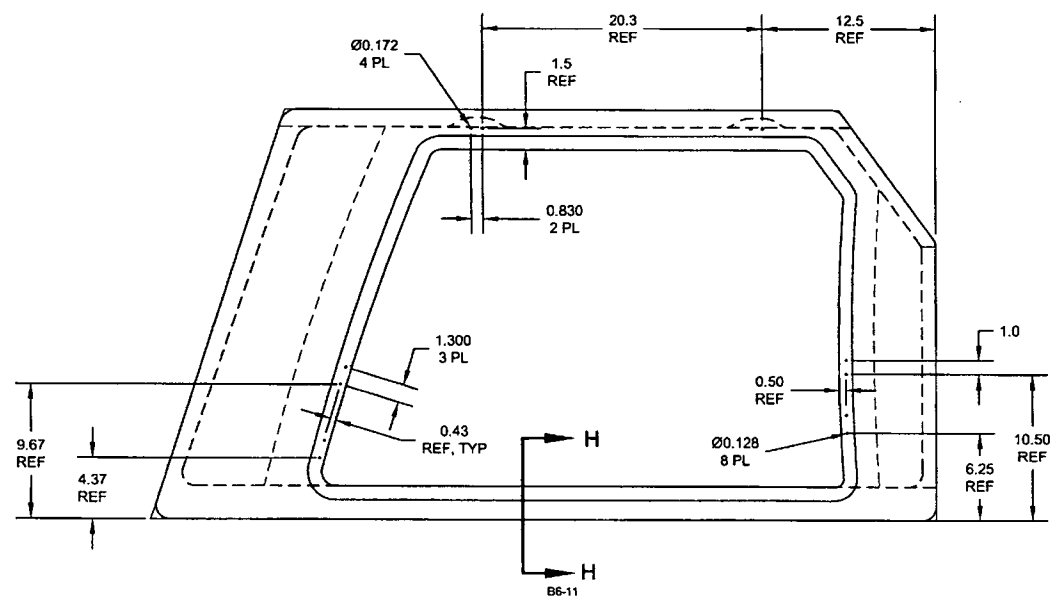
9) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

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WORK ORDER  
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09-10-22

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MD

F	REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENTS STANDARDS; ADD CHAMFER IN SECTIONS A-A (ZN C7-10) & H-H (ZN B7-11)	RF	09.07.13
E	ADD HYSOL/ FIBER OPTION ON SHEET 11	CB	07.04.02
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7	CB	06.10.06
A	NEW ISSUE	CP	03.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 1 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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**D3188-1 SPACEPOD BODY**  
MAKE FROM D3188-1M

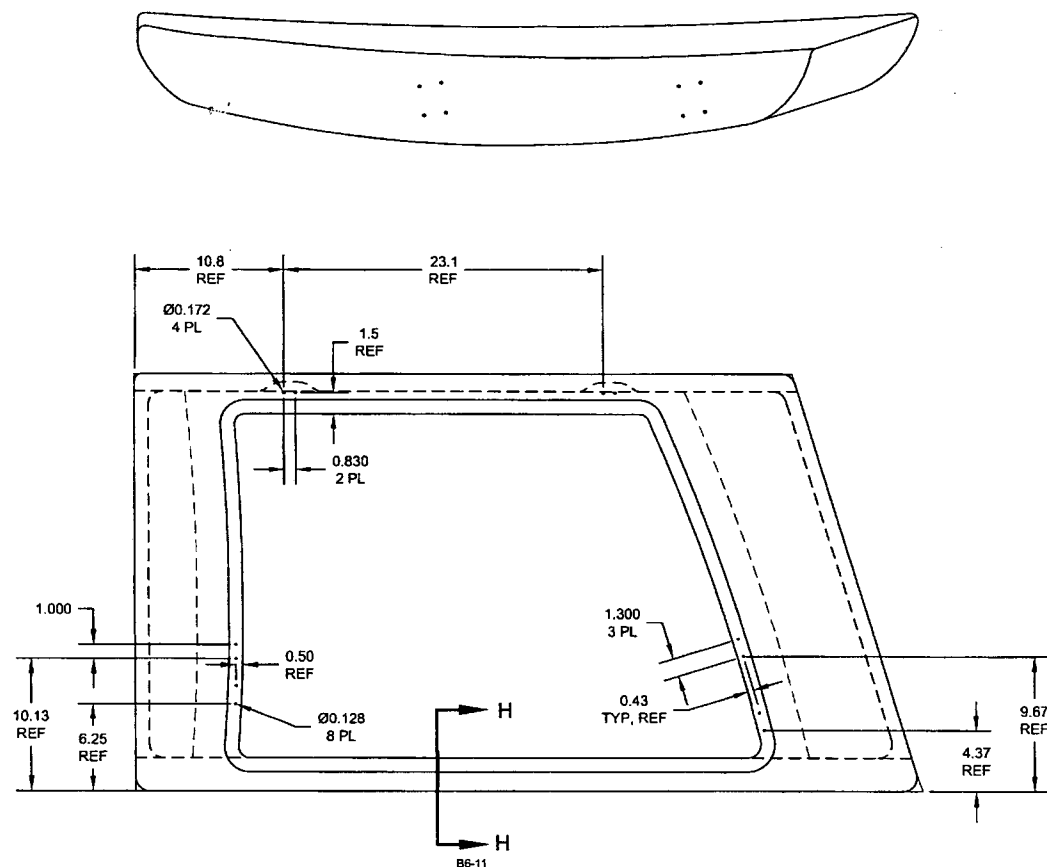
**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

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DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	<b>HAWKESBURY, ONTARIO, CANADA</b>	
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 2 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NTS
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**D3188-2 SPACEPOD BODY**  
MAKE FROM D3188-2M

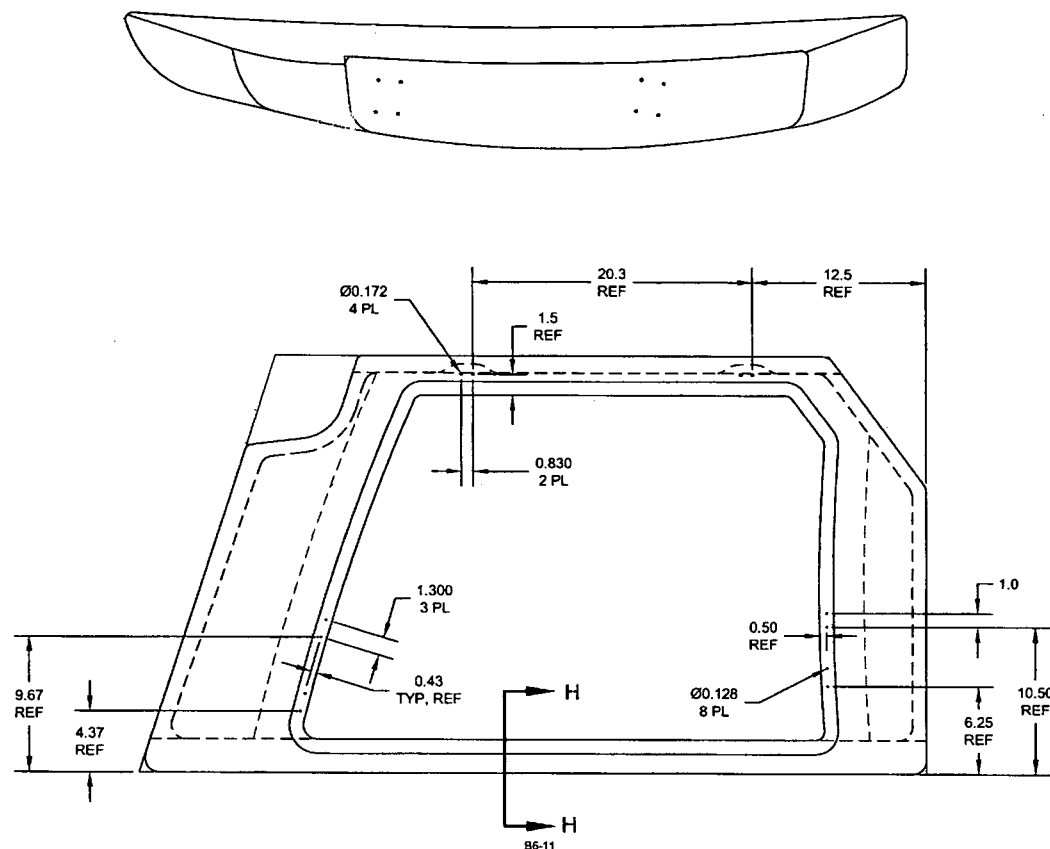
**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEW

**RELEASED**  
2009-10-20  
*MP*

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3188	SHEET 3 OF 11
APPROVED		TITLE	SCALE
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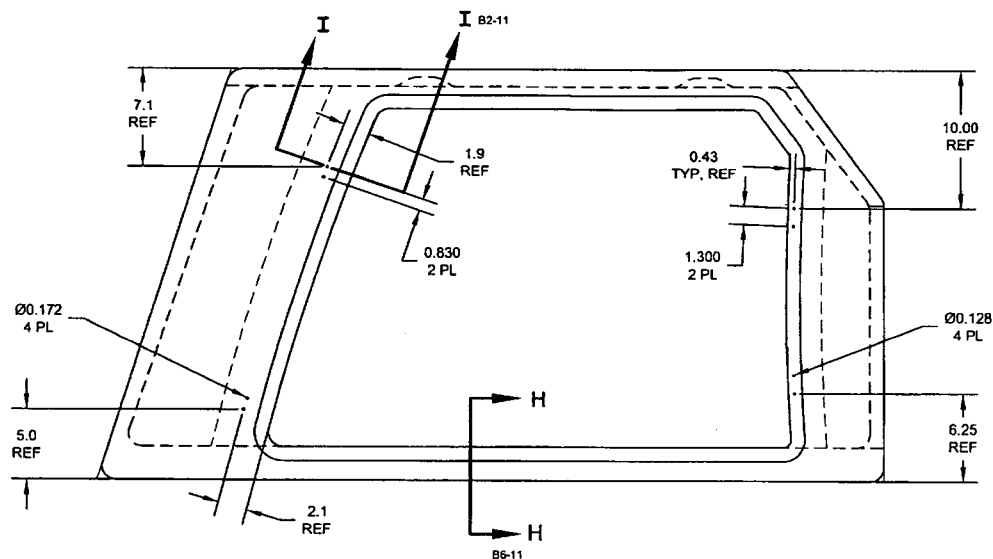


**D3188-3 SPACEPOD BODY**  
MAKE FROM D3188-3M

**RELEASED**  
2009-10-20

- NOTES:  
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 4 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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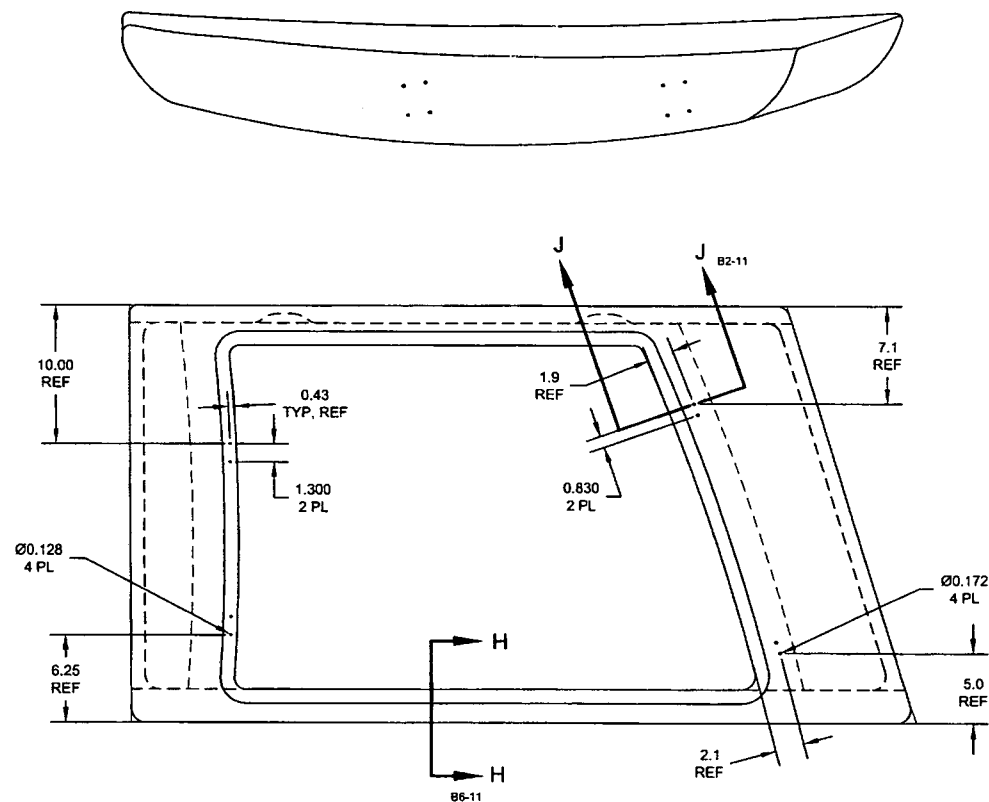
RELEASED  
2009-10-20

1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE  
TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY  
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
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CHECKED	<del>RF</del>	DRAWING NO.	REV. P
MFG. APPR.	<del>RF</del>	D3188	SHEET 5 OF 1
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	SPACEPOD BODY	NT
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**D3188-6 SPACEPOD BODY**  
MAKE FROM D3188-2M

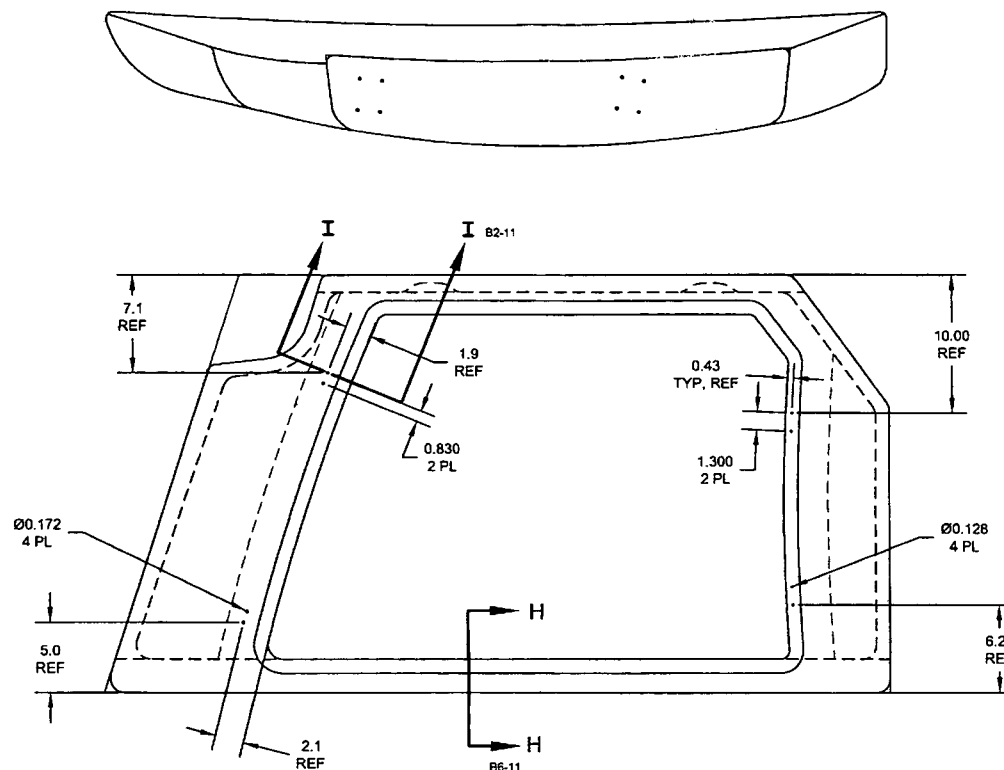
**RELEASED**  
2009-10-20

**NOTES:**

- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 6 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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**D3188-7 SPACEPOD BODY**  
MAKE FROM D3188-3M

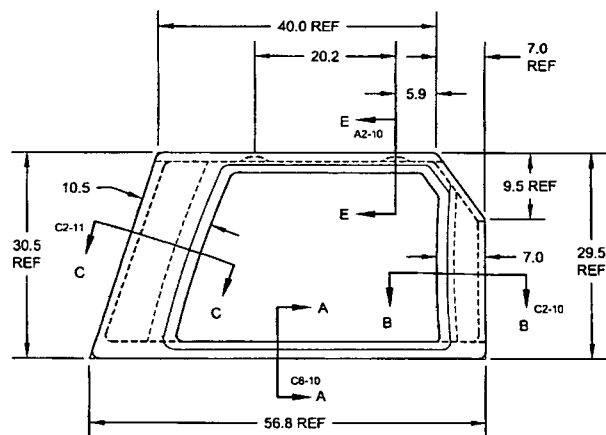
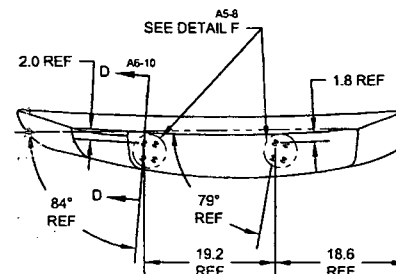
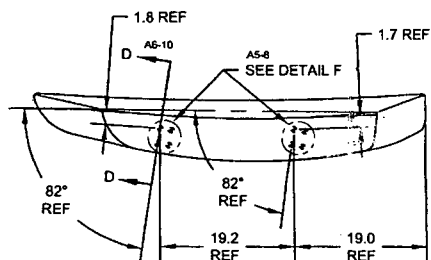
**RELEASED**  
2009-10-20  
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**NOTE:**

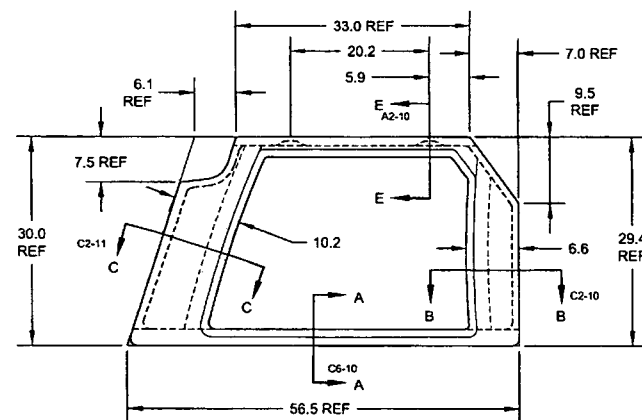
- 1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
- 2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 7 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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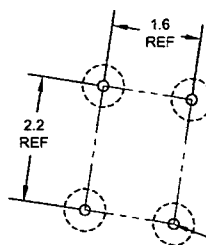
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**D3188-1M SPACEPOD BODY**



**D3188-3M SPACEPOD BODY**



**DETAIL F**





D3-8  
D7-6

INSTALL  
D2213 SPACER  
8 PL  
SEE SECTION D-D  
A6-10

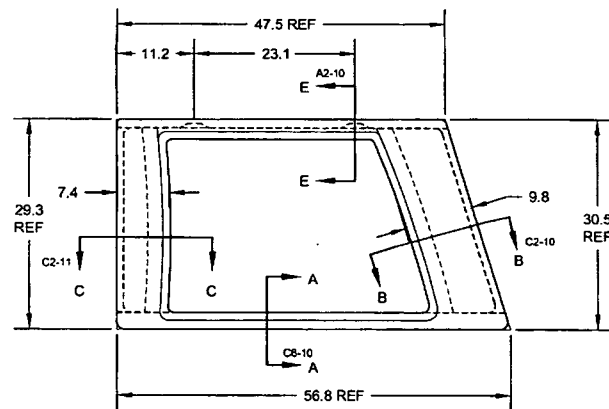
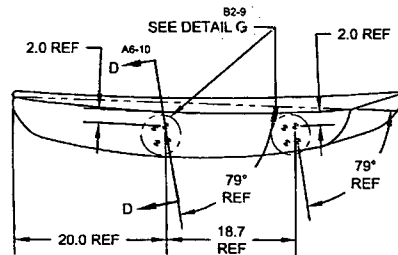
**D3186-1M/-3M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

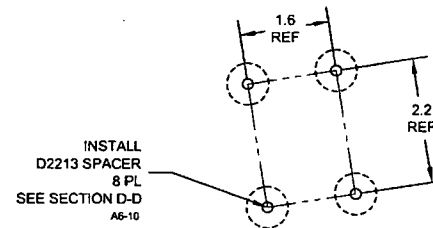
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MFG. APPR.		D3188	SHEET 8 OF 11
APPROVED		TITLE	SCALE
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**D3188-2M SPACEPOD BODY**



**DETAIL G** D6-9

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2009-10-20

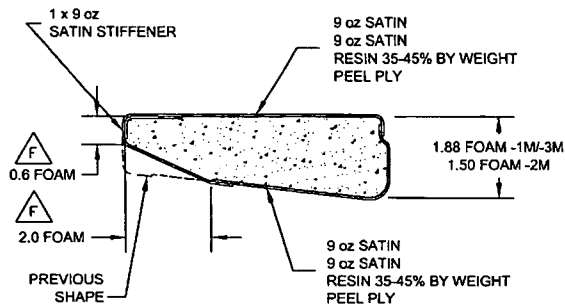
**D3188-2M NOTES:**

- 1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
- 2) SEE SHEET #10 FOR SECTION VIEWS.

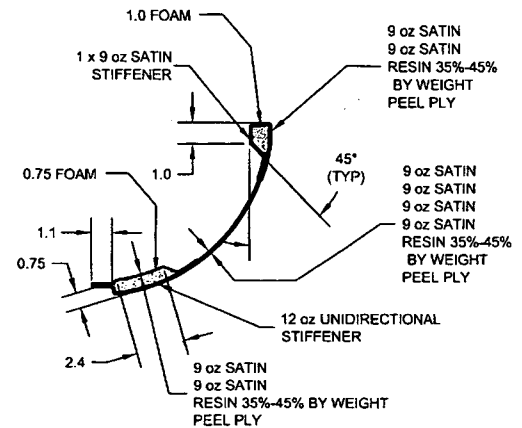
DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>[Signature]</i>	D3188	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD BODY	NTS
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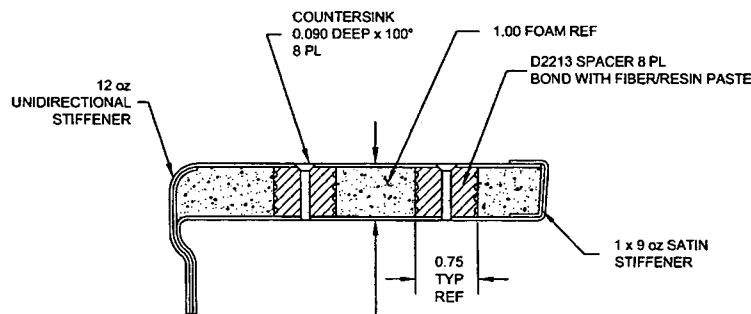
OUTBOARD



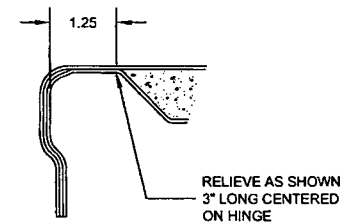
**SECTION A-A**  
TYPICAL FLOOR SECTION  
B7-8  
B3-8  
B6-8



**SECTION B-B**  
SECTION C-C OPPOSITE  
B6-8  
B8-8  
B4-8  
B2-8  
B7-8  
B5-8



**SECTION D-D**  
TYPICAL ROOF SECTION IS SIMILAR  
BUT WITHOUT INSERTS  
D3-8  
D7-8  
D6-8

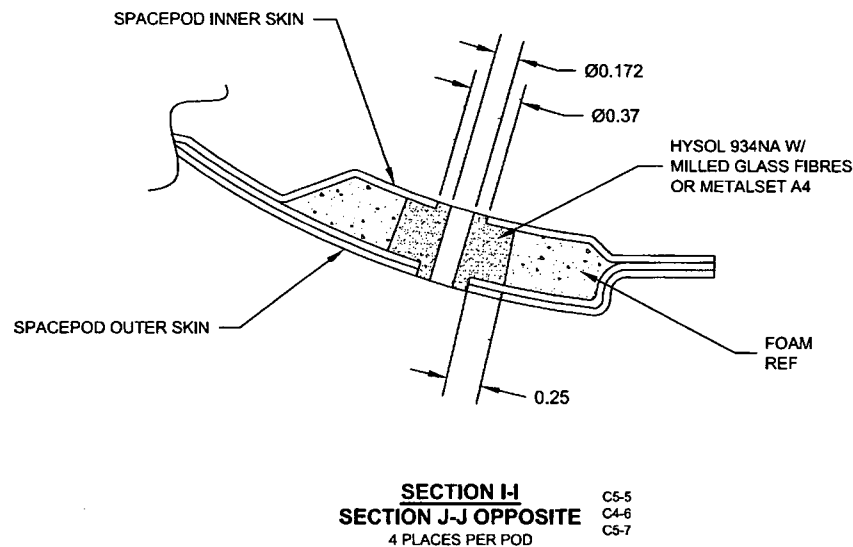
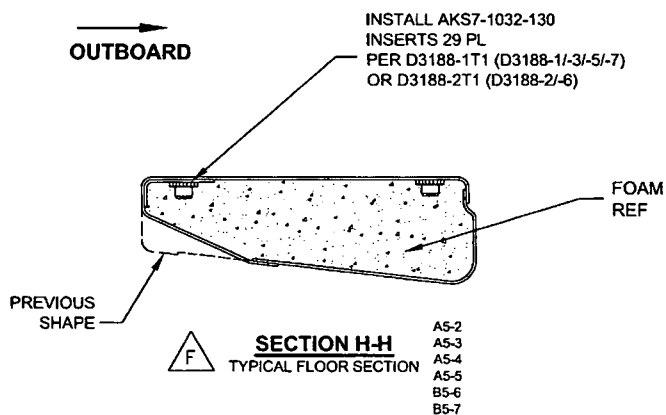


**SECTION E-E**  
2 PLACES PER POD  
C2-8  
C7-8  
B6-8

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2009-10-20

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. F
MFG. APPR.	<del>RF</del>	D3188	SHEET 10 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
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MFG. APPR.	<del>RF</del>	D3188	SHEET 11 OF 11
APPROVED	<del>RF</del>	TITLE	SCALE
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## 5.0 PARTS LIST

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
X							D130-780-041	SPACEPOD™ LH, EC 130 B4
	X						D130-780-042	SPACEPOD™ RH, EC 130 B4
1		X					D130-780-043	DOOR ASSEMBLY, LH
	1		X				D130-780-044	DOOR ASSEMBLY, RH
1				X			D130-780-011	LH SLIDING DOOR HINGE KIT
1	1				X		D130-780-013	SWITCH RELOCATION KIT
				1		X	D130-780-015	CLOSEOUT KIT
2	2						D3815-041	WEB ASSEMBLY
3	3						D3815-5	PACKER
		1	1				D2589	KEYS, KEY CHAIN
1	1						D3837-1	DECAL
1	1						D3015-3	LOCK NUT
		1					D3186-3	SPACEPOD™ DOOR, LH
			1				D3186-4	SPACEPOD™ DOOR, RH
1							D3798-041	FLOOR
	1						D3798-042	FLOOR
1							D3188-5	SPACEPOD™ BODY
	1						D3188-6	SPACEPOD™ BODY
1	1						D3547-1	BRACKET
1	1						D3550-1	STRUT
		1	1				D3552-7	GAS SPRING
1	1						D3554-7	BALL STUD
4	4						AN3-3A	BOLT
4	4						AN3-6A	BOLT
2	2						AN3-10A	BOLT
1	1						AN5-5A	BOLT
38	38						AN525-10R7	SCREW
8	8						AN526C832R14	SCREW
6	6						MS24694S54	SCREW
7	7						MS24694S67	SCREW
1	1						MS24694S69	SCREW
		2	2				MS27039-0811	SCREW
8	8						A3235-020-935	WASHER
14	14						NAS1149D0363J	WASHER
16	16						NAS1149D0332J	WASHER
		4	4				NAS1149DN832J	WASHER
3	3						NAS1149D0563J	WASHER
		2	2				NAS1515H3	NYLON WASHER
		2	2				MS21042L08	NUT
22	22						MS21042L3	NUT (or MS21042-3)
1	1						MS21042L5	NUT
10	10						AKS7-1032-130	INSERT
28**	28**						AKS7-1032-130	INSERT
10	10						MS21059L3	NUTPLATE

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Revision: B

Date: 09.06.11

-041	-042	-043	-044	-011	-013	-015	Part Number	Description
					2		D3819-1	MALE SPADE CONNECTOR
					2		D3597-1	FEMALE SPADE CONNECTOR
					1		D3598-2-096	EXPANDABLE SLEEVE
					24		D3599-1	TIE-WRAP
					24		D3600-1	TIE-WRAP MOUNT
					24 FT		M22759/41-22-9	WIRE
		1*	1*				D2464-1250	NEOPRENE SEAL
1**		1*					D3837-3	DECAL
	1**		1*				D3837-4	DECAL
		2*	2*				D2586	LATCH
		2*	2*				D2585	MOUNTING CHANNEL
		2*	2*				D2621	LATCH PLATE
		2*	2*				MS27039-1-15	SCREW
		2*	2*				NAS1149D0363J	WASHER
		2*	2*				MS21042L3	NUT (or MS21042-3)
		1*	1*				D2857-1	HINGE BRACKET
		1*	1*				D2857-2	HINGE BRACKET
		2*	2*				D2228	BACKING PLATE
		8*	8*				AN526C832R10	SCREW
		8*	8*				NAS1149DN832J	WASHER
		8*	8*				MS21042L08	NUT
		1*	1*				D3557-1	BRACKET
		2*	2*				D2228	BACKING PLATE
		1*	1*				D3554-7	BALL STUD
		1*	1*				NAS1149D0563J	WASHER
		1*	1*				D3015-3	LOCK NUT
		2*	2*				AN526C832R14	SCREW
		2*	2*				AN526C832R10	SCREW
		4*	4*				NAS1149DN832J	WASHER
		4*	4*				MS21042L08	NUT
2**	2**						D2237	STRIKER PLATE
4**	4**						MS20426AD4-5	RIVET
2**	2**						D3538-1	HINGE BRACKET
2**	2**						D2179	HINGE BRACKET PLATE
4**	4**						AN526C832R24	SCREW
4**	4**						NAS1149DN832J	WASHER
4**	4**						MS21042L08	NUT
				1			D3813-041	HINGE ASSEMBLY, UPPER DOOR
				1			D3813-043	HINGE ASSEMBLY, LOWER DOOR
				2***			D3518-3	ROD END

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Revision: B

Date: 09.06.11



-041	-042	-043	-044	-011	-013	-015	Part Number	Description
	1			2***			NAS509-6	NUT
				1			D3814-1	HINGE, UPPER AIRFRAME
				1			D3814-3	HINGE, LOWER AIRFRAME
				2			D3816-1	SPACER
				4			D3816-3	SPACER
				1			D3817-041	ANCHOR PLATE
				2			AN3-5A	BOLT
				3			AN3-7A	BOLT
				2			AN310-4	CASTLE NUT
				2			AN4-17	BOLT
				2			AN970-4	WASHER
				5			MS21042L3	NUT
				2			MS24665-212	COTTER PIN
				3			MS24694S46	SCREW
				8			NAS1149D0363J	WASHER
				2			NAS1149D0463J	WASHER
				1			D3552-7	GAS SPRING
				2			D3622-1	BALL STUD
				1			D3820-1	DOOR SUPPORT
				2			MS21042L5	NUT
				2			NAS1149D0563J	WASHER
				1			D3892-1	SEAL
						1	D3983-1	OUTER CLOSEOUT
						1	D3983-3	INNER CLOSEOUT
						1	D3983-5	HINGE CLOSEOUT
						1	D3983-047	CLOSEOUT ATTACHMENT
						1	D3983-9	SPACER
						2	AN525-10R6	SCREW
						1	AN525-10R24	SCREW
						1	NAS1149D0363J	WASHER
						1	MS21042L3	NUT

\* Pre-installed on D3186-3/-4 Spacepod™ Door

\*\* Pre-installed on D3188-5/-6 Spacepod™

\*\*\* Pre-installed on D3813-041/-043 Hinge Assemblies

REFERENCE ONLY

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D130-780 REV. B OR LATER APPROVED REVISION  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D130-780 REV. 1 OR LATER ACCEPTED REVISION

REF. TCCA STC: SH93-88  
REF. FAA STC: SR00098NY  
REF. EASA.IM.R.S.01292

The purpose of this DSI is to provide an alternate door prop for the D130-780-011 LH Sliding Door Hinge Kit.

In service experience has shown that LH Sliding Doors may have significantly more weight associated with their installation due to executive style finishing versus the standard utility LH Sliding Door. This extra weight requires a more powerful door prop to operate the door.

For D130-780-011 at CHG 003, the D3552-7 door prop is replaced with a D3552-13 door prop as follows:

IS

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-13	DOOR PROP

WAS

-041	-042	-043	-044	-011	-013	-015	PART NUMBER	DESCRIPTION
				1			D3552-7	DOOR PROP

Customers with D130-780-011 at CHG 002 or earlier, may procure the DSI 9502-011 kit to replace the D3552-7 door prop with a D3552-13 door prop as follows:

-011		
X	DSI 9502-011	REPLACEMENT DOOR PROP KIT
1	D3552-13	DOOR PROP

- 1) Remove the D3552-7 door prop from the ball studs
- 2) Install the D3552-13 per IIN-D130-780 and ICA-D130-780.
- 3) Update parts list in IIN-D130-780 and ICA-D130-780 to reflect the part number change.
- 4) Make an entry in the technical record of the aircraft indicating that DSI 9502 has been accomplished.






Weight and Balance change associated with this DSI is negligible.

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 10.02.03  
CERT. NO.: SH93-88  
ISSUE NO.: 6

A	NEW ISSUE	BY	DATE
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>DSI 9502</b> REV. A SHEET 1 OF 1 TITLE <b>REPLACEMENT DOOR PROP</b> SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	10.02.03		